

Date: Tuesday, 19/08/2008 4:07:27 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT PLATE		
Job Number	: 41512-1			Part Number	: PB674300171		
Estimate Number	: 13385			Drawing Number	: B6743001 P.9/26		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/08/2008 S.O. No. :			Drawing Revision	: B1		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 18/09/2008 Qty: 30 Um: Each		
Previous Run	: 40244			<i>split.8</i>			
Written By	:						
Checked & Approved By	: JLD 08.8.20						
Comment	: Est Rev:A 08-06-19 new issue DD verified by:ec Est Rev:B 08-06-27 procedure chg DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6S090	6061-T6 .090 Sheet		
 Comment: Qty.: 0.8594 sf(s)/Unit Total : 25.7828 sf(s) 6061-T6 .090 Sheet batch: 109184 <span style="margin-left: 100px;">IB 8-9-9</span>				
2.0	WATER JET	FLOW WATER JET		
 Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-159 Dwg Rev: B1 <span style="margin-left: 100px;">IB 8-9-9</span> Prog Rev: B1 <span style="margin-left: 100px;">IB 8-9-9</span> ****grain direction along 5.750" **** 2-Deburr if necessary <span style="margin-left: 100px;">IB 8-9-9</span>				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="margin-left: 100px;">IB 8-9-9</span>				
4.0	QC8	SECOND CHECK <b>POSITIVE RECALL</b> EFFECTIVE <u>08.09.09</u> AUTH <u>d</u>  Comment: SECOND CHECK RELEASED <u>11</u> DATE <u>08.09.10</u> <span style="margin-left: 100px;">Soobay (10 +30)</span>		
5.0	BRAKE NC	NC BRAKE		
 Comment: NC BRAKE 1- countersink as per drawing <span style="margin-left: 100px;">Dwg 09/09/11 (30)</span> 2- Bend as per Dwg B67-43001 <span style="margin-left: 100px;">So 08/09/15 (29)</span>				

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-71 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/09/16

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 41512		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/16	5	I piece <del>was</del> was out of tolerance RC poor drawing	/	Scrap & destroy No reply	SB 08/09/16	/	Asian	08/09/16

NOTE: Date &amp; initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 41512

Part Number: PB674300171

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



calculated

Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-weld as per dwg B67-43001

08.09.22 8

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-grind weld flush

08.09.24 8

9.0 QC10

VISUAL INSPECTION OF GROUND WELDS



XE

5080816 828

Comment: VISUAL INSPECTION OF GROUND WELDS

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 065.4.1

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Nutplate

M109068

5080816 828

14.0 MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 360.0000 Each(s)

RIVET

M105978

5080816 828

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:27 PM  
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## Process Sheet

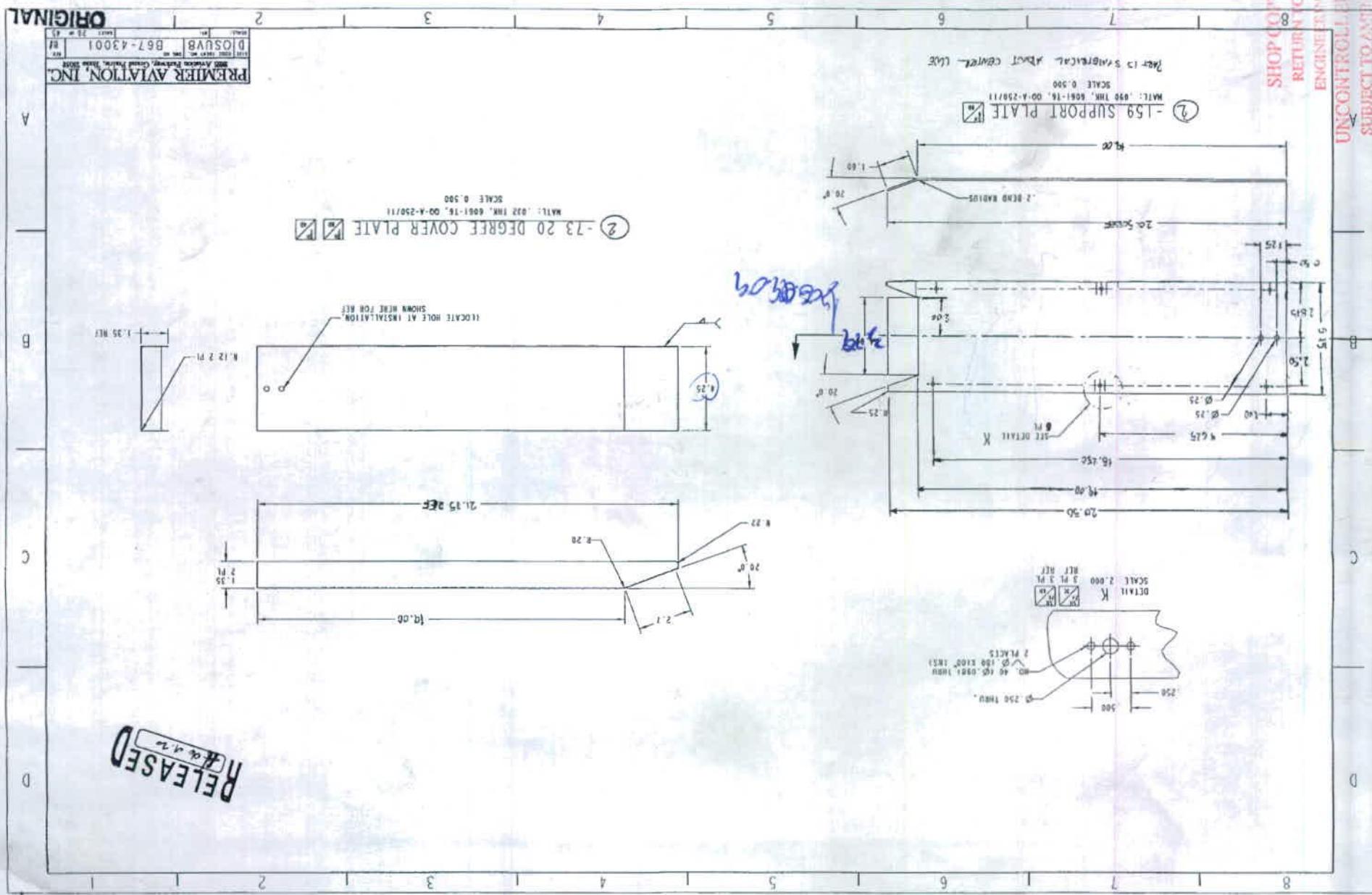
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT PLATE
Job Number: 41512		Part Number: PB674300171
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
15.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 1-install nut plates as per dwg B67-43001 <i>8/08/09/24 (8)</i>
16.0	QC5 	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP <i>8/08/09/24 (8)</i>
17.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>246</i> <i>8/08/09/24</i> <i>50</i>
18.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>08/09/26 (8)</i> <i>MF 08-09-25</i>
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

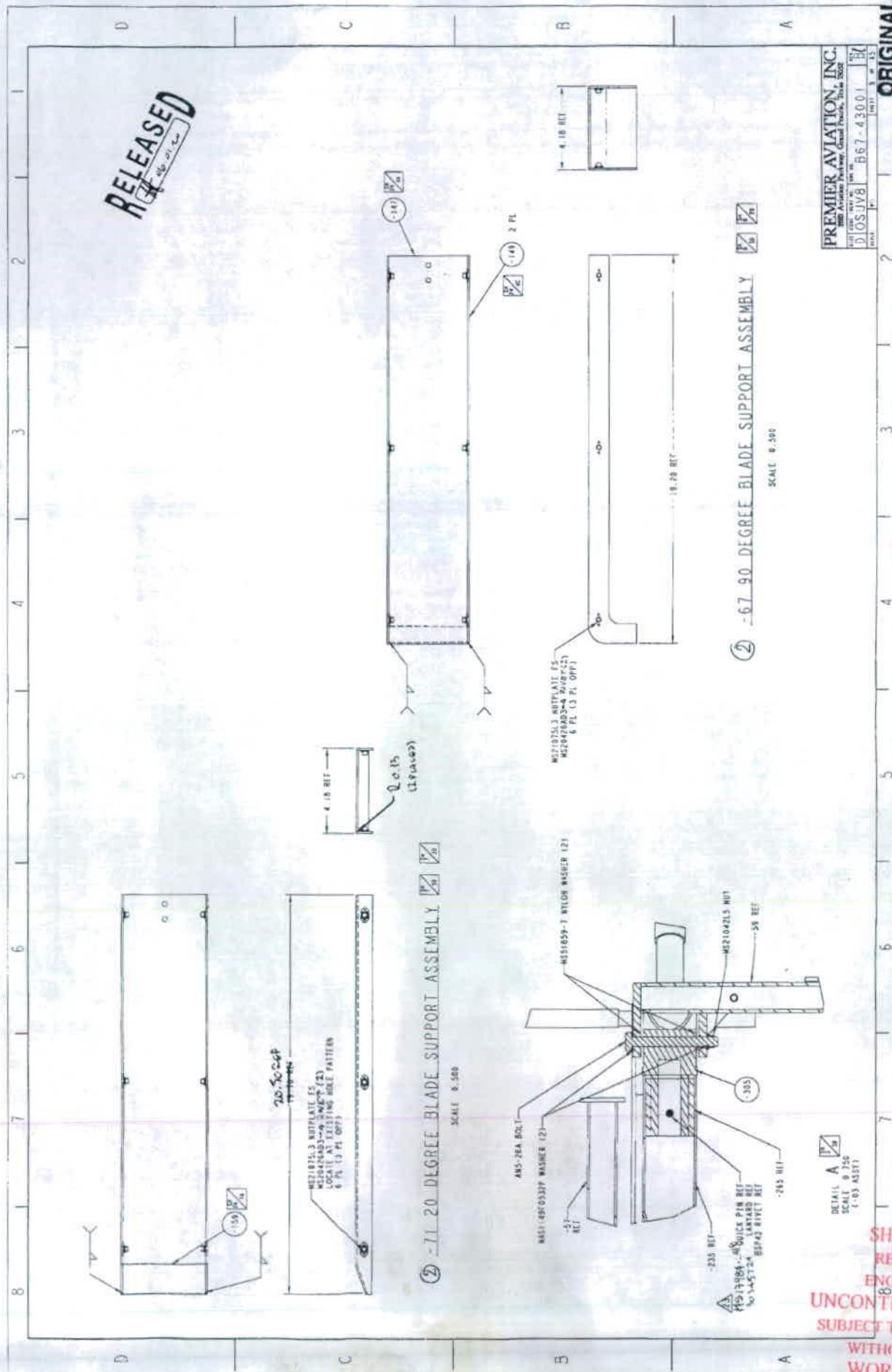
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





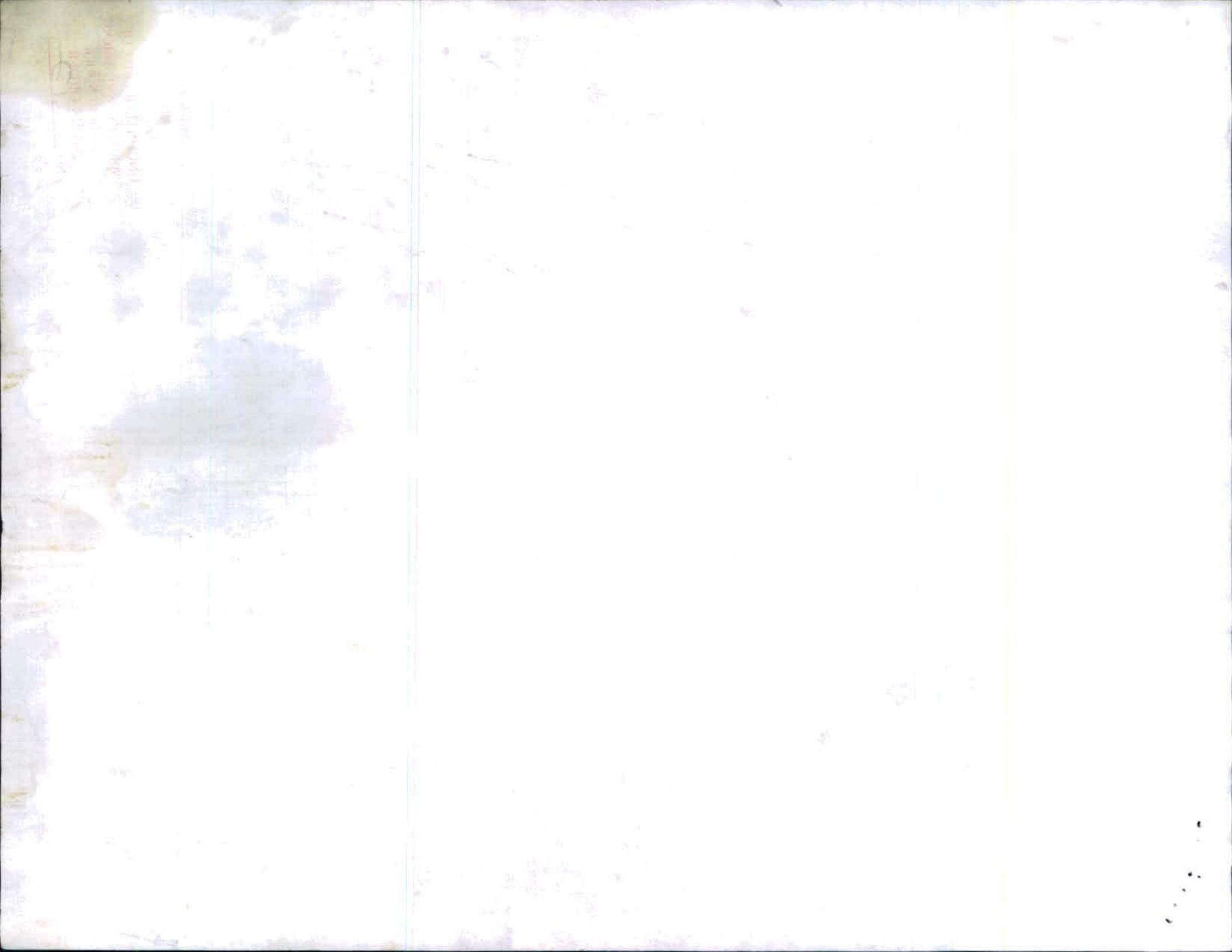
RELEASED  
4/15/2012



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 41512

PREMIER AVIATION, INC.  
100 Aviation Parkway, Duluth, GA 30097  
TEL: 770.944.1100 FAX: 770.944.1101  
E-MAIL: [info@premavia.com](mailto:info@premavia.com)

ORIGINAL



DART AEROSPACE LTD

Work Order: 41517

Description: SUPPORT PLATE

Part Number: PB6743001-~~EF~~

Inspection Dwg: Rev: B1

Page 1 of 1

PB C74 3001-154

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

**Measured by:**

10

**Audited by:**

### Prototype Approval:

Date: \_\_\_\_\_

89-9

Date:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	P/O PB67-43001-71	KJ/JLM

